Work	Order	ID	74616	
Monday,	October 0	3. 201	1 4:06:0)2 PM



Page 1

Item ID:
Revision ID:
Item Name:

D3535-13

Accept



Setup Start



Start Date:

Required Date: 10/5/2011

Wearshoe 10/3/2011

QC:

Start Qty: 6.00 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MLJ

Revision Nbr

Date: 11 10 0 Tooling:

Date:

Run

Start



Date:_

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description

Set Up/ **Run Hours** Tool ID

Tool# Plan Code

Accept **Q**ty

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr D3535

Rev B

FLOW CNC Waterjet

304.040

FLOW WATER JET

Memo

0.00

□Dwg Rev:

0.00

_□Prog Rev: \$\mathcal{L}\$

B11-10-07

Waterjet

110

QC2- Inspect parts off machine FAI/FAIB

1-Cut as per Dwg D3535

Deburr if necessary

0.00

Memo

0.00

B11-10-27

Quality Control

QC8- Inspect parts - second check

Memo

251011n B

120



Quality Control

Dart Ae	rosnace	1 td								
W/O:	Ториос	. 210	WO	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAI			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No) :	PAR #:	Fault Categ	gory:	NCR:	Yes I	No DQ	A:	Date: _	
	R	esolution:	Disposition	n:	QA: N	/C Clo	sed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	IANCE (NCR	· · · · · · · · · · · · · · · · · · ·			
		Description of NC		Corrective Action Sec	ction B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	1	ion C	Chief Eng	QC Inspecto
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	}								1	

Monday, October 03, 2011 4:06:02 PM

Page 2

Item ID:

D3535-13

Accept

Setup Start

Stop



Revision ID:

Start Date:

Wearshoe Item Name:

Required Date: 10/5/2011

10/3/2011

Start Oty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID** Operation Description Set Up/ **Run Hours** Tool ID

Tool# Plan Code

Accept Qty

Reject Oty

Reject Insp. Number Stamp

130

Brake NC

NC BRAKE

Memo

0.00

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326 2-Form S II II (5) joggle as per Dwg D3535 using Jig DT81581dentify as D3535-13

140

Brake NC

Ouality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

150

Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

Memo

Mefulato

ART TIME: 3 DIFINISH TIME: 3 WWW. SANDE

Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANGE	ES				
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
									
	<u> </u>								

Work Order ID 74616

Monday, October 03, 2011 4:06:02 PM



Page 3

Item ID:

D3535-13

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 10/5/2011

Wearshoe

10/3/2011

Start Qty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date: _____

Date:

Tooling:

Set Up/

Run Hours

Date:

Run

Start

Stop



QC:

SPC (Y/N):

Date:

Reject

Reject

Insp.

Sequence ID/ Work Center ID

160

Quality Control

Operation **Description**

QC3- Inspect Part Finish

Memo

0.00

0.00

Tool ID

Tool # Plan Code Accept Qty

Qty

Number

Stamp

170

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

G BR 11-11-2.

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace l	Ltd
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W/O:			VV	ORK ORDER CHANGI	ES				
DATE	STEP	PRC	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		tion C	Chief Eng	QC Inspector
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Picklist Print

Monday, October 03, 2011 4:06:07 PM

Work Order ID: 74616

Parent Item:

D3535-13

Parent Item Name: Wearshoe



Start Date: 10/3/2011

119346

Required Date: 10/5/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-02-15 JLM

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	170.5795		5.37157	-		
304/316 .040 Sheet						•					1811-10-	-27	•
				Location		Loc (<u>Qty</u>	Loc Code				\	
				MAT020		170.5	5795				_		
					116623		0.2		_		_	16	
					117550	8	3.363				_	(\mathcal{A})	
					117933	45.3	3442				_		

118400

118964

119346

33.6723

83

Dart Aeros	pace Ltd
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W/O:		WORK ORDER CHANGES							
DATE	STEP	PRO	PROCEDURE CHANGE					Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes I	No DQA	\ :	_ Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C Clo	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NCR))		-	
DATE	STEP	Description of NC		Corrective Action Secti		Verific	ation	Approval	Approval
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DART AEROSPACE LTD	Work Order:	74616
Description: Wearshoe	Part Number:	D3535-13
Inspection Dwg: D3535 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1,888	>		V 1B02	_
2.000	+/-0.010	000.6	2		ν	
5.650	+/-0.010	5.650	~		T BUI	
9.150	+/-0.010	9,156	2		7	_
14.066	+/-0.010	14.066	2		7	
18.983	+/-0.010	18.983	,		7	
23.900	+/-0.010	∂3.9∞	6		7	
27.400	+/-0.010	27460	8		τ .	
29.400	+/-0.010	29.400	7		7	
32.900	+/-0.010	33.900	D	·	7	-
Ø0.188	+0.005/-0.001	189	7		V	
20.00	+/-0.030	30.00	مد		7	
14.00	+/-0.030	14.00	R		7	
8.00	+/-0.030	60.8	7		7	
5.00	+/-0.030	5,00	2		T	
0.300	+/-0.010	. 300			ν	
0.300	+/-0.010	- 301	7		V	
0.038	+/-0.010	036	>		1/	
					V	

Measured by: B	Audited by:	Prototype Approval:	N/A
Date: パーローカ	Date: u 10/28	Date:	N/A

Rev	Date	Change	Revised by _∧	Approved
Α	08.04.15	New Issue	KJ/DD 🛠	X

Dart Aerospace Ltd

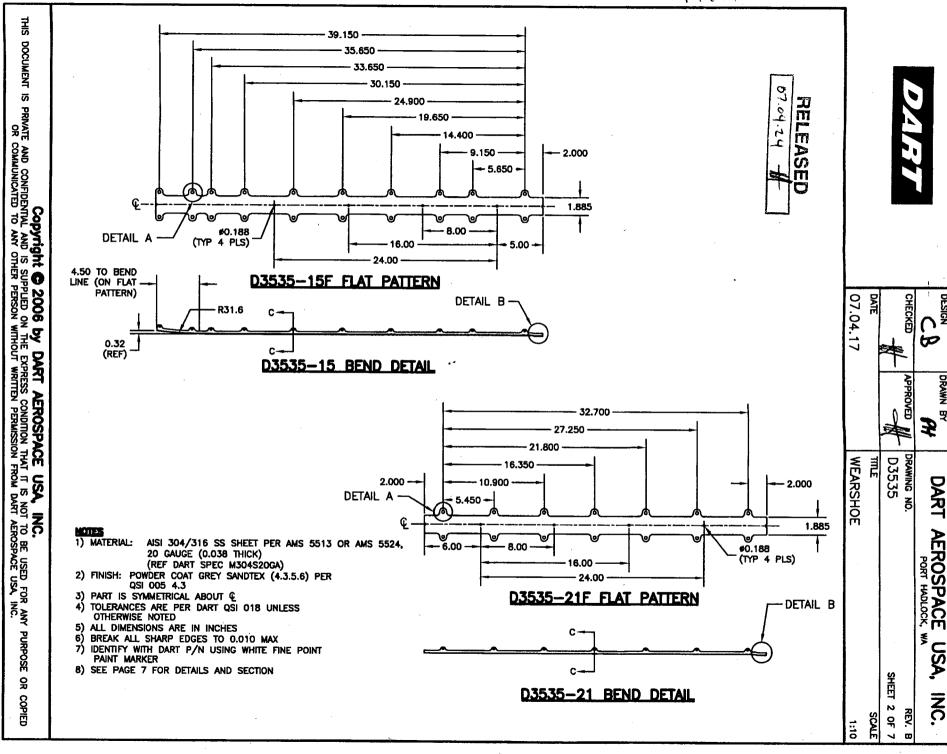
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Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES									
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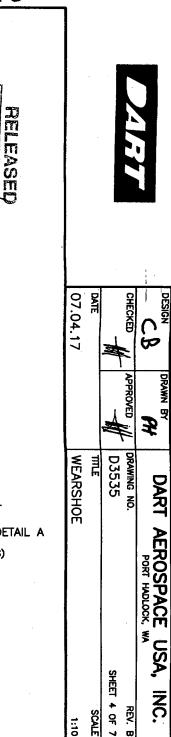
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22.500 19.000 9.500 6.000 2.000 1.885 **#0.188** (TYP 3 PLS) D3535-31F FLAT PATTERN



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•	D3535-31	BEND	DETAIL

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DART L

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PURPOSE

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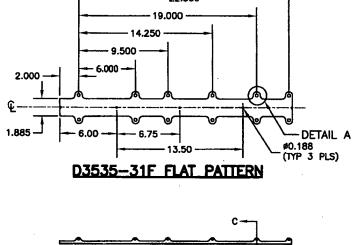
1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT Q
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

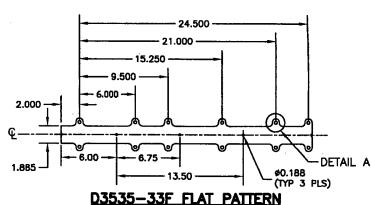
5) ALL DIMENSIONS ARE IN INCHES

6) BREAK ALL SHARP EDGES TO 0.010 MAX

IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER

8) SEE PAGE 7 FOR DETAILS AND SECTION





D3535-33 BEND DETAIL

Dart	Aerospace	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
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DATE	STEP	Description of NC		<u></u>	tion B	Verifi	cation	Approval	Approval
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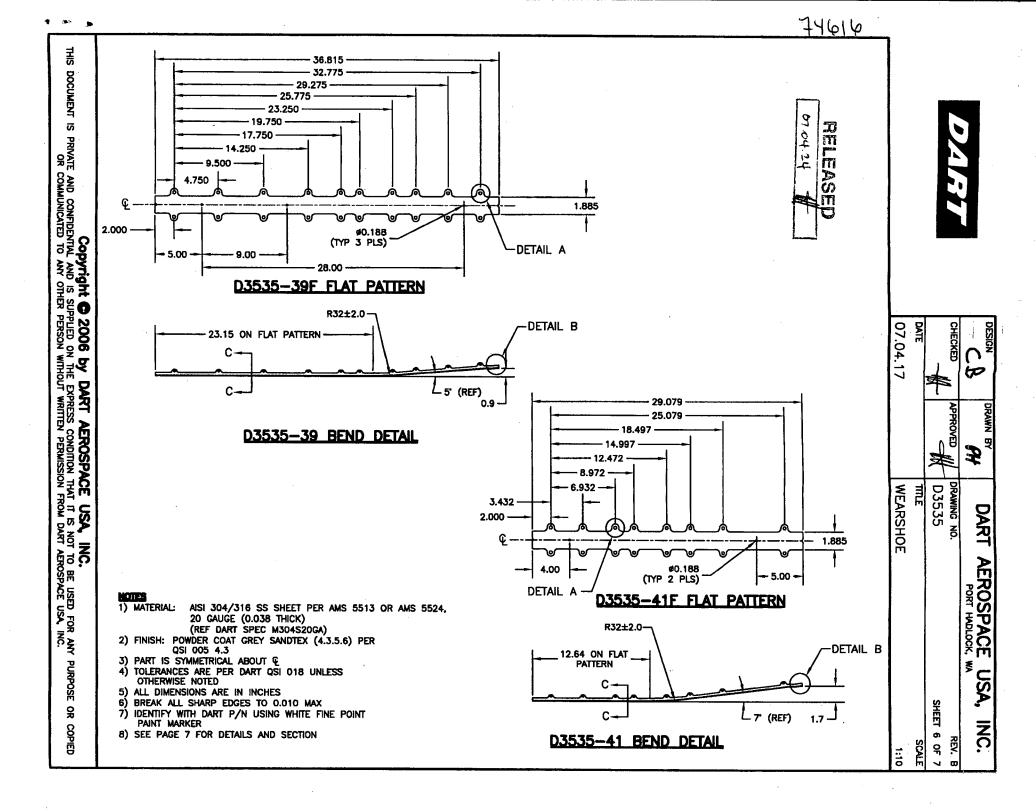
PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. たなら 14.250 9.500 4.750 2.000 #0.188 1.885 (TYP 2 PLS) DETAIL A D3535-35F FLAT PATTERN 07.04.17 D3535-35 BEND DETAIL O 27.250 22,500 3 17.750 DRAWING NO. WEARSHOE DART 4.750 2.000 AEROSPACE PORT HADLOCK, 6.00 1.885 DETAIL A 16.00 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER
QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT ©
4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCLESS 21.00 #0.188 (TYP 4 PLS) D3535-37F FLAT PATTERN PURPOSE 5) ALL DIMENSIONS ARE IN INCHES 6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT SHEET 욹 ZC. D3535-37 BEND DETAIL COPIED PAINT MARKER 5 OF 7 8) SEE PAGE 7 FOR DETAILS AND SECTION 1:10

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W/O:	· · · · · · · · · · · · · · · · · · ·		WORK ORDER (CHANGES				
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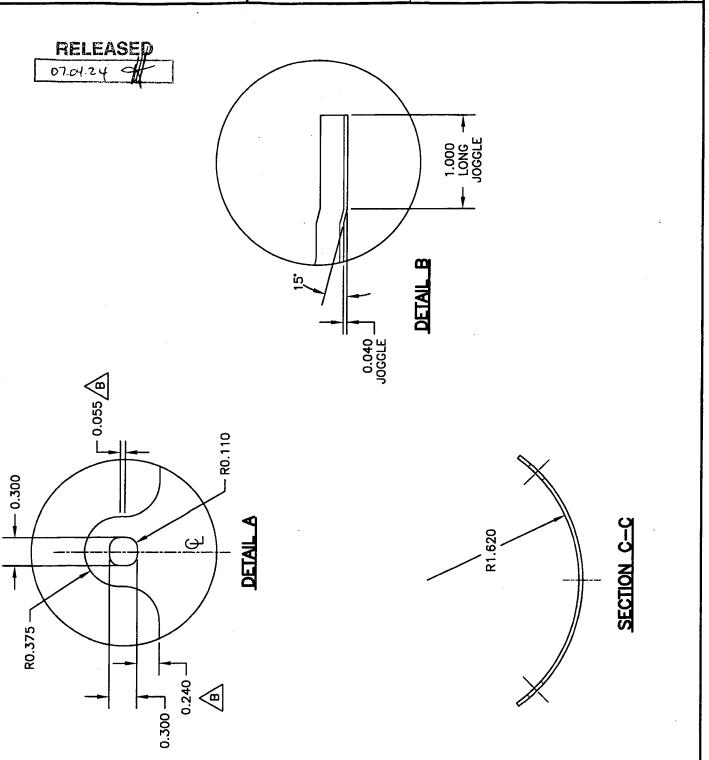
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		Description of NC		Corrective Action Section B	3	Verification	Approval	Approval		
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DESIGN DART AEROSPACE USA, PORT HADLOCK, WA DRAWN BY INC. CHECKED DRAWING NO. REV. B APPROVED D3535 SHEET 7 OF 7 DATE TITLE SCALE 07.04.17 **WEARSHOE** 1:1



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